

ASAP

129601

Page 1

Accept

N900040100

Setup **Start** ***NS1***

Stop *NS2*

Start Date: 2/19/15 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 3/06/15 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr				
D3488	Rev B				
DSK101	REV D				
100			0.00		
100	DOOSAN LATHE				DAS
Doosan	Memo		0.00		25
Doosan Lathe	1-Turn as per Dwg DSK 101 & Folio FA625				9-89
	2-Deburr				15-3-1E
110					
	QC2- Inspect parts off machine FAI/FAIB		0.00		
110					DAS
QC	Memo		0.00		25
Quality Control					9-89
					15-3-1E

Work Order ID 129601

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Item ID: D3488-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Blade Fitting LH
Start Date: 2/19/15 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 3/06/15 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	HandFinishing	0.00							
180	HandFinish	0.00				x 8	8	13/05/06	
Hand Finishing	Memo Install Inserts as per Dwg D3488								
190	QC5- Inspect part completeness to step on W/O	0.00							
190	QC	0.00				8	15-5-14	853	
Quality Control	Memo								
200	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
200	Packaging	0.00				x 8	8	15/05/06	
Packaging	Memo								

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Item ID: D3488-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blade Fitting LH
Start Date: 2/19/15 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 3/06/15 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ MAY 04 2015

MLJ MAY 04 2015

Picklist Print

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Work Order ID: 129601

129601

Parent Item: D3488-041

D3488-041

Parent Item Name: Blade Fitting LH

Start Date: 2/19/15

Required Date: 3/06/15

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-225

AELS8-1032-225

Purchased

No

Each

120.0000

AI S7-1032-225

Insert

**

32
11 1516576.1

Location

Loc Qty

Loc Code

FG

120

11131657

(132)

118520

120

Each

7.0000

8

D6103-003

Manufactured

No

D6103-003

Round Billet, Aluminum

**

415311

Location

Loc Qty

Loc Code

MAT043

7

113646

7

129603

8

DART AEROSPACE LTD		Work Order: 179681
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number: D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

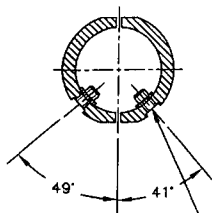
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.150	/		T-G+VERN	SL-10
Ø2.780	+/-0.005	2.780	/		mic	SL-6
Ø3.125	+/-0.010	3.124	/		VERN	
Ø3.346	+/-0.010	3.345	/		~	
0.125 x 45°	+/-0.010 x +/-0.1°	0.125x45°	/		~	
8.000	+0.030/-0.000	8.014	/		H-G	
9.250	+/-0.010	9.250	/		H-G	
0.188	+/-0.010	0.189	/			
R0.032	+/-0.010	0.032	/			
R0.062	+/-0.010	0.062	/			
Ø0.297	+0.005/-0.001	0.298	/		VERN	
Ø0.430	+/-0.010	0.431	/		"	
0.100	+/-0.010	0.102	/		"	
0.125	+/-0.010	0.127	/		"	
2.620	+/-0.010	2.619	/		"	
3.500	+/-0.010	3.500	/		~	
1.005	+/-0.010	1.005	/		H-G	
Ø0.484	+0.005/-0.001	0.485	/		VERN	
1.180	+/-0.010	1.180	/		~	
3.150	+/-0.010	3.150	/		-	
3.070	+/-0.010	3.068	/		H-G	
R0.063	+/-0.010	0.063	/			

DART AEROSPACE LTD		Work Order:	729601
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.509	✓		gauge	PIN
0.750	+/-0.010	.7485	✓		Height gauge	
1.500	+/-0.010	1.502	✓		SL08	Vern
11.18	+/-0.030	11.170	✓		Height gauge	
R0.062	+/-0.010	.062	✓		Rad gauge	
0.125	+/-0.010	.118	✓		Height gauge	
0.590	+/-0.010	.591	✓		"	
0.793	+/-0.010	.7945	✓		"	
1.351	+/-0.010	1.348	✓		Height gauge	
1.317	+/-0.010	1.324	✓		SL03	Mic
1.802	+/-0.010	1.800	✓		Height gauge	

Measured by: SL	DAS 20 9-89	Audited by:	DAS 14 9-89	Prototype Approval:	N/A
Date: 15-3-11 / 15-03-22		Date: 15-03-24		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	

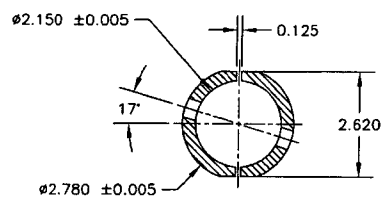


SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

4

al0129601



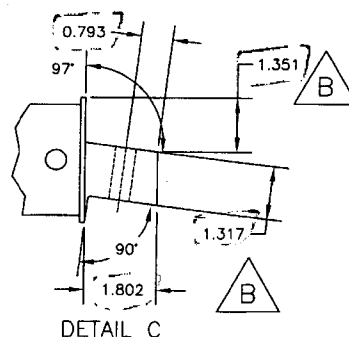
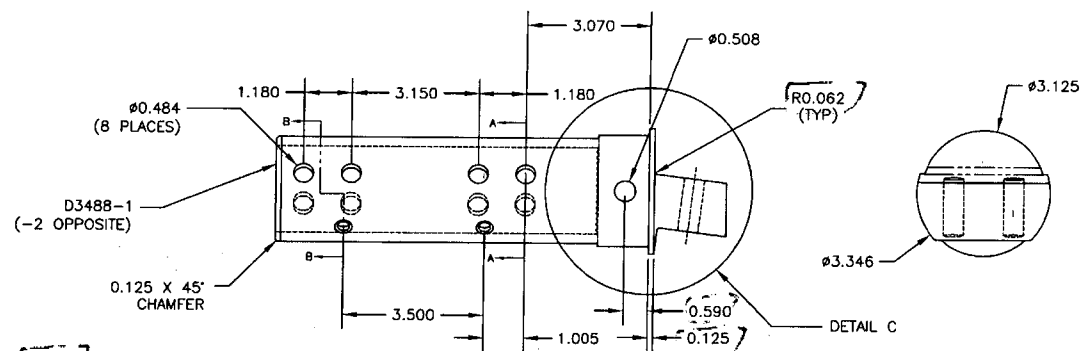
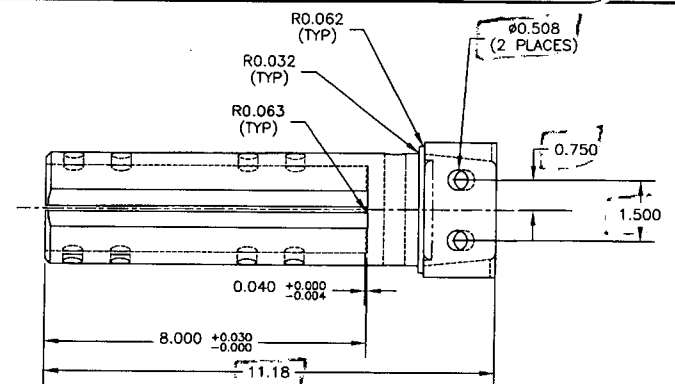
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
04-05-14 PH
PER DS
ICN #739

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
		DRAWING NO. D3488
		REV. B
		SHEET 1 OF 1
		SCALE
		1:3

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